

Split

Date: Wednesday, 2/8/2008 10:24:15 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 37238 -2		
Estimate Number	: 12784		
P.O. Number	:	Part Number	: D35649
This Issue	: 2/6/2008 S.O. No. :	Drawing Number	: D3564 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 36637	Material	:
Written By	: <u>08 02 06</u>	Due Date	: 2/18/2008
Checked & Approved By	:	Qty:	12 Um: Each
Comment	: Est Rev A New Issue 07-03-08 ec Est Rev B As per Rev C 07-07-09 JLM Est Rev C As per Rev D 07-09-09 JLM Verified By: EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 1.1550 sf(s)/Unit Total: 13.8600 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: 106860 IB 8-2-11

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3564 ***** (D3564-1F) *****
Dwg Rev: D
Prog Rev: D IB 8-2-11
2-Deburr if necessary IB 8-2-11



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Deburr if necessary
Form on Brake as per Dwg D3564 using Jigs DT 8155 and DT 8175

Form Joggle as per Dwg D3564 on brake using Jig DT 8157

08/02/20 (12) 88

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 37238

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Johnston (12)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3564

4106834

8/1 08/03/04

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-01

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/04 (4)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442

m-l 08/03/04

(4X)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q-m 08. 03. 04 (4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

F P 18

m-l 08/03/04

(4X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/05

Job Completion



2008/3/04

(4)

1870

1871

1872

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DART AEROSPACE LTD		Work Order:	37238
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

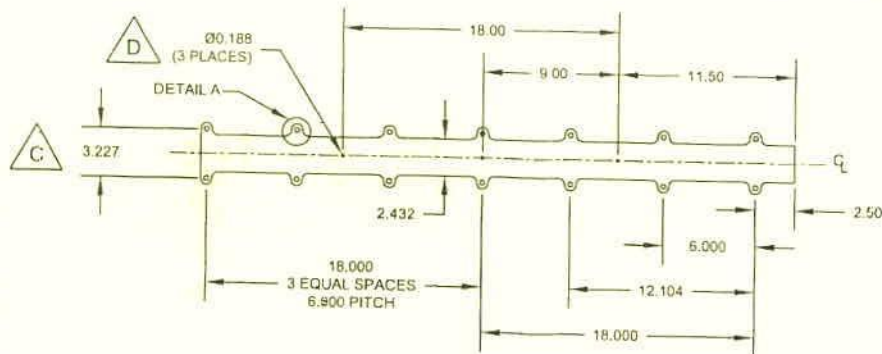
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.235	X			
2.432	+/-0.010	2.440	X			
2.50	+/-0.030	2.50	X			
6.000	+/-0.010	6.000	X			
12.104	+/-0.010	12.104	X			
18.000	+/-0.010	18.000	X			
18.000	+/-0.010	18.000	X			
18.00	+/-0.030	18.00	X			
9.00	+/-0.030	9.00	X			
11.50	+/-0.030	11.50	X			
0.300 x 0.300	+/-0.010	301 x 301	X			
Ø0.188	+0.005/-0.001	.189	X			
R0.375	+/-0.010	.375	X			
0.063	+/-0.010	.060	X			

Measured by:	B
Date:	8-7-11

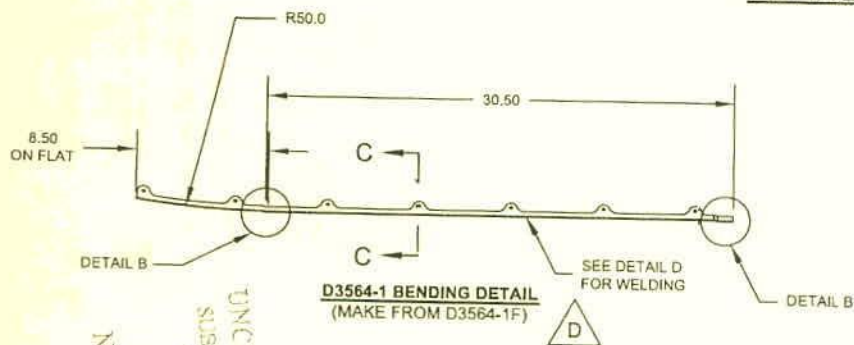
Audited by:	J
Date:	08/2/12

Prototype Approval:	N/A
Date:	N/A

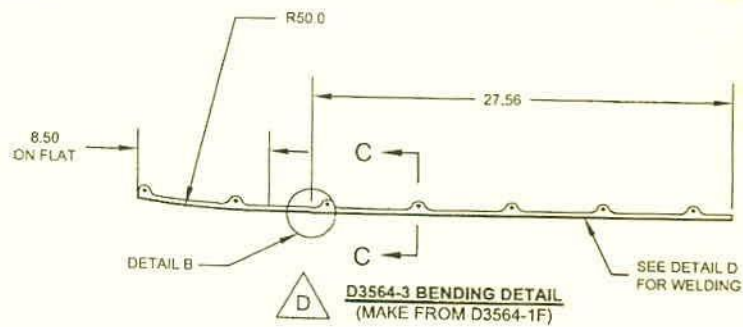
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

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D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT CL

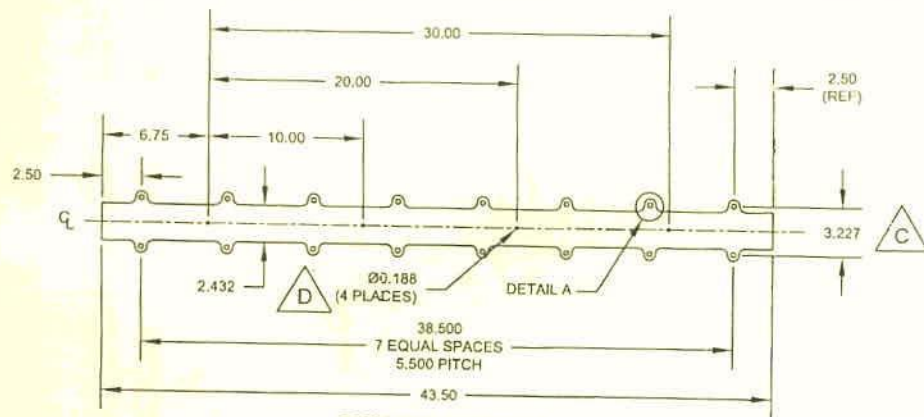
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR	PH		
APPROVED	PH		
DE APPR	PH		
DATE	07.08.21		

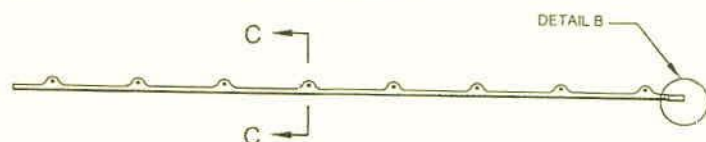
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. D
D3564 SHEET 1 OF 3
TITLE SCALE
WEARSHOE 1:8

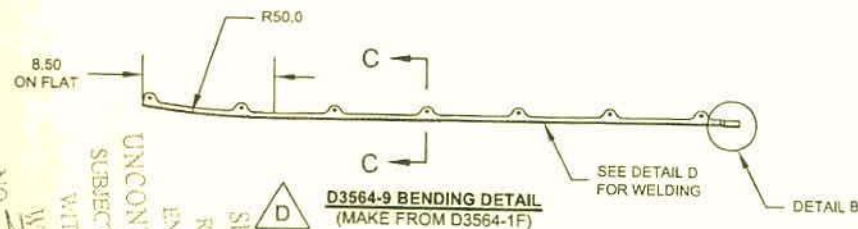
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D3564-5F FLAT PATTERN

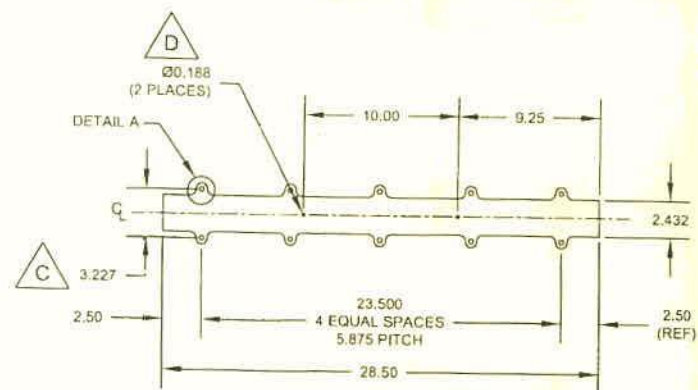


D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)

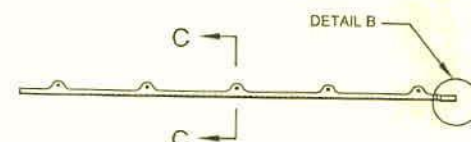


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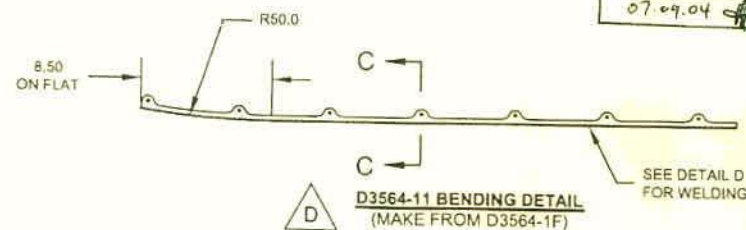
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D3564-7F FLAT PATTERN



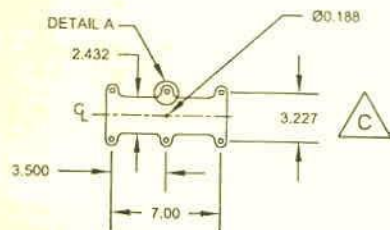
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



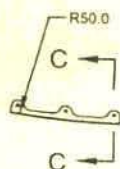
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

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07.09.04

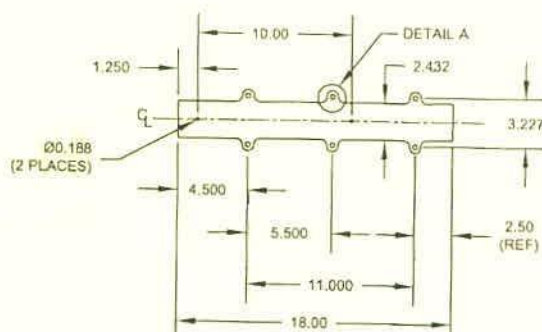
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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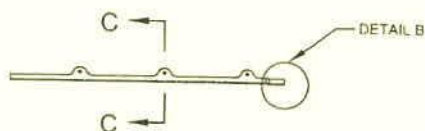
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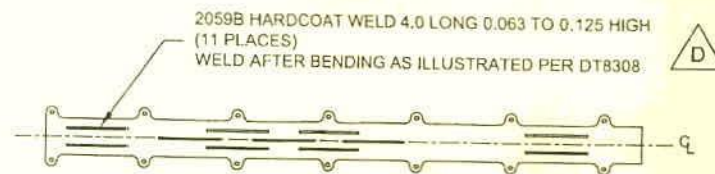
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D3564-15F FLAT PATTERN



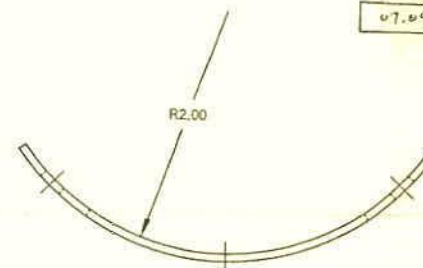
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



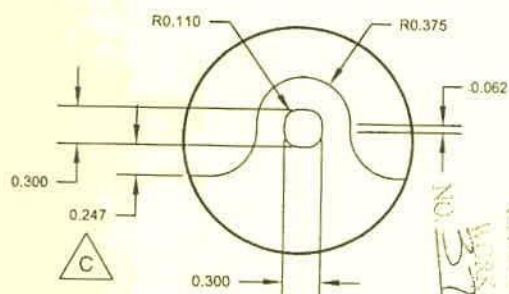
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED

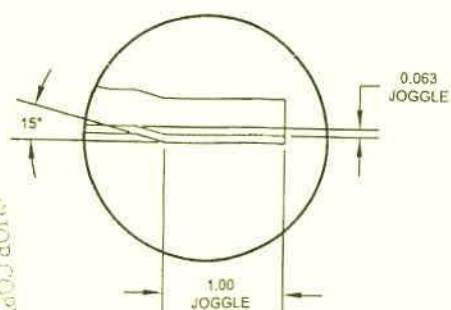
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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3/2/08

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CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR	PH	D3564	SHEET 3 OF 3
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